Packaging

Packaging

May-21-13 7:44:25 AM Item ID: D3975-041 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Gas Cylinder Assembly, LH **Start Date:** 5/21/13 Start Otv: 5.00 Cust Item ID: Required Date: 5/28/13 Reg'd Oty: 5.00 **Customer:** Reference: Run. Process Plan: MLJ Date: 13-05-21 Tooling: Approvals: Date: QC: Date: SPC (Y/N): Date: Operation Sequence ID/ Set Up/ Tool ID Reject Tool # Plan Accept Reject Insp. Work Center ID Description **Run Hours** Code Qty Qty Number Stamp **Draw Nbr Revision Nbr** D3975 В 110 0.00 \*110\* Small Fab 0.00 Memo Small Fab apply decal as per dwg 120 QC5- Inspect part completeness to step on W/O \*120\* QC Memo Quality Control Identify as per dwg & Stock Location 130 \*120\*

0.00

Memo

NCR: Ye	es / No				WORK ORDER NON-	CONF	ORN	MANCE / UPI	DATE						
										QA Closed:	Dat	te:			
Work Orde	ŕ:				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Part No	o.			Rework Scrap	-		Skid-tube Aachining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality				
					Use-as-is	1   T		oforming	Finishing	<b>⊣</b>	re/Packaging	Other			
NCR N	0				Work Order Update	]		Large Fab	Composite		Supplier				
Root	Į.	,		Descr	iption of work order update	Initi	ial	Act	ion	Sign &	·				
Cause	Date	Date Step Qty			or Non-conformance	Chief	Eng	Descr	ription	Date	Verification	n QC Inspector			
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					F	AULT C	ATEC	ORY			-				
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	Bending				Bend	☐ Gr	ain			Ovalized	ļ	Pressure/Forced			
	Centre N	ot Concei	ntric to (	o/s	BOM/Route	Ha	ırdwar	re		Over/Under	tolerance	Temperature/Cure			
	Cracks				Broken/Damaged	Ins	pection	on incomplete		Part Incorred	it [	Weld			
	Crushed/	Crimped			Burrs	ins	structi	ons Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
Γ	Cuffs				Contamination	Ma	ainte	nance		Part Moved	_				
ſ	Heat Treat				Countersink	Mi	islabel	ed		Positioned V	/rong	·			
Γ	Inspectio	n Strip in	Tube		Cut Too Short	Мі	isread			Power Loss/	Surge	Other			
	Ripples in	n Bend			Drill Holes	Off	fset		<u></u>	_	•				
,	Torque W	Vaves in E	xtrusio	, ·	Drawing	Пои	it of C	alibration							
	Turning S				Finish	Пou	it of S	equence							
	Wave/Tw				Folio	Outside Dimensions									

Date: \_\_

DQA:

May-21-13 7:44:25 AM Item ID: D3975-041 Accept \*N900040100\* Setup Start **Revision ID:** Gas Cylinder Assembly, LH Item Name: Start Qty: 5.00 **Start Date:** 5/21/13 **Cust Item ID:** Required Date: 5/28/13 Req'd Qty: 5.00 **Customer:** Reference: Run Process Plan: Date: Approvals: Tooling: Date:

Stop QC: \_\_\_\_\_ Date: \_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Qty /Number Code Stamp 140 QC21- Final Inspection - Work Order Release 0.00 \*140\* 0.00 Memo

Quality Control

MF

13-5-30

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NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	·co	NFOR	MANCE / UP	DATE	•	•	* .		
÷									-		QA Closed:	Date:			
Work Orde	o					DISPOSITION	AGAINST DEPARTMENT/PROCESS								
Part No						Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root				-	Descri	ption of work order update		Initial	Act	tion	Sign &				
Cause		Date	Step	Qty	(	or Non-conformance	CI	hief Eng	Desci	ription	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
							FAU	LT CATE	GORY						
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		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio	Crimped at n Strip in		o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misreac	on Incomplete ions Incomplete/l nance led		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned W Power Loss/S	st ssing //	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other		
j		Ripples in	Bend		1	Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

May-21-13 7:44:29 AM

Work Order ID: 101882

Parent Item:

\*101882\*

D3975-041

\*D3975-041\*

91905

Parent Item Name: Gas Cylinder Assembly. LH

**Start Date:** 5/21/13

Required Date: 5/28/13

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP RevA: New issue DD verified by:EC 10.05.27 as per ECN10-548 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D3975-1		Manufactured	No			110	Each	10.0000	1	5		
*D3975-1* Gas Cylinder									**		FF	- 13-05-2
				Location		Loc (	Qt <u>y</u>	Loc Code				
				GA			10			_	_	
D00=4.4				p	91873		10		_	5	_	
D3976-1		Manufactured	No			110	Each	11.0000	1	5		
*D3976-1*									**		F	= 13-05-2
				Location		Loc (	<u>Oty</u>	Loc Code				
				ST081			11		·		_	
•					72050		1			1		

10

											DQA	\:	Date:		
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Work Ord	٥ŕ٠					DISPOSITION	AGAINST DEPARTMENT/PROCESS								
Work Ord	CI.					Rework	7		Skid-tube	Crosstube	7	Water Je	≥t	Engineering	
Part I	No.					Scrap	1	6	Machining	Small Fab	Pr	od. Eng. Coo	-	Quality	
						Use-as-is	1	2	noforming	Finishing		ore/Packagin	<del></del>	Other	
NCR No.						Work Order Update			Large Fab	Composite	]	Supplie	:r		
		1	<del>,                                    </del>	•			_		r		T 6: 0	1		· · · · · · · · · · · · · · · · · · ·	
Root						ption of work order update		Initial		tion	Sign &				
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Landi	ing (	Gear				General									
Bending						Bend		Grain			Ovalized			Pressure/Forced	
		Centre N	ot Conce	ntric to	o/s 🗀	BOM/Route		  Hardwa	re		Over/Unde	r tolerance		Temperature/Cure	
		Cracks				Broken/Damaged		Inspecti	ion Incomplete		Part Incorr	ect		Weld	
	$\Box$	Crushed/	Crimped			Burrs	Instructions Incomplete/Unclear				Part Lost/N	/lissing		Wrong Stock Pulled	

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

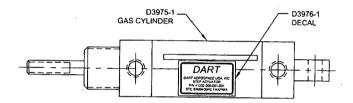
Inspection Strip in Tube

Torque Waves in Extrusion

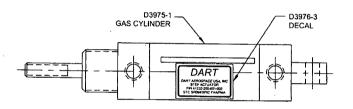
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ITEM No.	QTY -041	QTY -042	PART NUMBER	DESCRIPTION
1	Х		D3975-041	GAS CYLINDER ASSEMBLY (LH)
2		Х	D3975-042	GAS CYLINDER ASSEMBLY (RH)
3	1	1	D3975-1	GAS CYLINDER
4	1		D3976-1	DECAL
5		1	D3976-3 /B	DECAL

UNCONTROLL (BOUT)



D3975-041 GAS CYLINDER ASSEMBLY



D3975-042 GAS CYLINDER ASSEMBLY

RELEASED 2010 -05- 20

В	CORRE	CTED TYPO	: D3976-3 WAS D3975-3 (ZN D7-1).	MB	10.04.13				
Α	NEW IS	SSUE		AJS	09.07.09				
REV.	<u> </u>		BY	DATE					
DESIGN	1	#35	DART AEROSPAC	DART AEROSPACE USA. IN					
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CHECK	ED	9	DRAWING NO.		REV. B				
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DE APP	R.	-#	GAS CYLINDER ASSEMBLY	Y	NTS				
DATE	10.04	4.13	COPYRIGHT © 2009 BY DART AER THIS DOCUMENT IS REVAITE AND CONTRIBUTION AND IS SUPPLIED NOT TO BE USED FOR ANY PURPOSE OR COMED ON COMMAND WITTEN REVAILSSOM FROM DAMI AREA						

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Work Ord	or.					DISPOSITION	AGAINST DEPARTMENT/PROCESS								
work order.					Rework	Skid-tube Crosstube			1	Water Jet	Engineering				
Part I	No.					Scrap	1	1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality		
					Use-as-is	1	4	noforming	Finishing	=	re/Packaging	Other			
NCR	No.					Work Order Update			Large Fab	Composite	]	Supplier			
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Unapproved															
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		Bending				Bend		Grain			Ovalized	L	Pressure/Forced		
		Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure		
	L	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct _	Weld		
		Crushed/	Crimped			Burrs	L	Instruct	ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled		
		Cuffs				Contamination		Mainte	enance		Part Moved				
		Heat Trea	at		[	Countersink		Mislabe	eled		Positioned V	Vrong			
	Г	Inspectio	n Strip in	Tube		Cut Too Short		Misread	<del>d</del>		Power Loss/	Surge	Other		

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

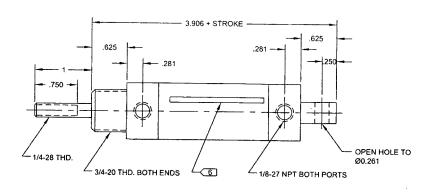
Drawing

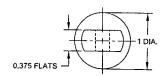
Finish

Folio

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D





**D3975-1 BRASS CYLINDER** 

D

NOTES:

1) MATERIAL: CROSS REFERENCE Era DRAWING 41232-200-007
PURCHASE P/N: HEAVY DUTY BRASS CYLINDER 7D1H
VENDOR: CLIPPARD INSTRUMENT LABORATORY, INC, CINCINNATI, OH.

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: IDENTIFY WITH Era P/N 41232-200-007-001 USING VIBRATING STYLUS

7) WEIGHT: 0.74 lbs APPROX

2) BORE: 0.875 INCHES 3) ROD: ROTATING.

5) TEMPERATURE RANGE: 30° F. TO 230° F.
6) MOUNT: UNIVERSAL MOUNT.

7) ACTION: DOUBLE ACTING.

8) STROKE: 1.000 INCH.

9) POWER FACTOR: 0.6 SQ. IN.

10) PORTS: 1/8 NPT.

11) ROD DIAMETER: 0.25 INCHES. 12) SINTERED BRONZE ROD BUSHING.

13) PRESSURE TEST: 2660 PSI (USE 5606 FLUID).

DESIGN DRAWN	755	DART AEROSPACE					
CHECKED	a)	DRAWING NO.	REV. B				
MFG, APPR,	N	D3975	SHEET 2 OF 2				
APPROVED	149	TITLE	SCALE				
DE APPR.	-#-	GAS CYLINDER ASSEMBLY	NTS				
DATE 10.0	4.13	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PROVIET AND CONTROL HITM A VID IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS HAVE TO BE USED TOM ANY IMPOSES OR COMPOSED ONE COMPANIES TO ANY OTHER MASON WITHOUT					

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Work Orde	ar.			ii	DISPOSITION		AGAINST DEPARTMENT/PROCESS								
Work Orde					Rework	7		Skid-tube Crosstube	٦	Water Jet	Engineering				
Part No.				Scrap	1		Machining Small Fab	Pro	d. Eng. Coor.	Quality					
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·	Cracks		•	<u> </u>	Broken/Damaged	$\vdash$	1	ion Incomplete	Part Incorred	<b>⊢</b>	Weld				
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	Cuffs			<u> </u>	Contamination	-	Mainte	<del>-</del>	Part Moved						
	Heat Tr	eat		_,	Countersink	1	Mislabe	eled	Positioned V	Vrong	•				

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Ripples in Bend

Turning Sequence

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Inspection Strip in Tube

Torque Waves in Extrusion

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Drill Holes

Drawing

Finish

Folio

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